

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018616**Date Inspected:** 11-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Shi Lei.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

Trial assembly yard, Connection Plate.

FCAW welding of weld joint USPL1-653-001; located at Trial assembly yard. Welder is identified as 040759; ZPMC Quality Control Inspector (QC) is identified as Zhu Zhong Hai. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-ESAB. The attached photographs provide additional detail.

Trial assembly yard, 12AE-12BE, EP-B3.

SMAW welding of weld joint CA6502-007; located at Trial assembly yard. Welder is identified as 040320; ZPMC Quality Control Inspector (QC) is identified as Li Yang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2214-B-U2-FCM-1. The attached photographs provide additional detail.

Trial assembly yard, 12AE-12BE, EP-F9.

SMAW welding of weld joint OBE12-001; located at Trial assembly yard. Welder is identified as 044515; ZPMC Quality Control Inspector (QC) is identified as Shi Lei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2214-B-U2-FCM-1.

Trial assembly yard, 11DE-11EE, BP-SP-E4.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

SMAW Repair welding (Ultrasonic Inspection repair per ZPMC UT-report # UT-11E-078) of weld joint SEG-074A-011(WRR # B-WR18688); located at Trial assembly yard. Welder is identified as 053871; ZPMC Quality Control Inspector (QC) is identified as An Qing Xiang. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-SMAW-1G(1F)-FCM-REPAIR-1. The attached photographs provide additional detail.

Trial assembly yard, 12AW-12BW, EP-F9, I-rib hold back area.

SMAW welding of weld joint EP3010-001-009, EP3011-001-005; located at Trial assembly yard. Welder is identified as 040656; ZPMC Quality Control Inspector (QC) is identified as Wang Zhu. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2112-FCM-1.

This QA Inspector carried out NDE on following Subassembly, Bay 06.

This QA inspector performs Random Ultrasonic Testing (UT) of approximately 10% area previously tested and accepted by ZPMC Quality Control personnel (Notification # 07730). This QA Inspector generated an UT report (TL-6027) for this date. The members are identified as

DP3166-001-001.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 1500.042.2372, who represents the Office of Structural Materials for your project.

| | | |
|----------------------|--------------------|-----------------------------|
| Inspected By: | Juvekar,Amit | Quality Assurance Inspector |
| Reviewed By: | Dsouza,Christopher | QA Reviewer |
